Work Order ID 90080 September-13-12 1:04:34 PM					*90080*									
Item ID: Revision ID: Item Name:	D3836-04	2 bly (Basket Lic	d, RH)		Accept	*N900	040	100)* s	etup Sta	i	S1* S2*		
Start Date: Required Date: Reference:	9/13/12 9/13/12	_	ty: 1.00 Pty: 1.00		(2X)	Cust Item I Customer:	D:					:		
Approvals:	Process I	Plan: <u>N</u>	L Σ	Date: √2- ↔	7-13 Tooling:	D	ate:		R	tun Sta	1/1	R1*		
				Date:	-	D:	ate:			Sto	*N	R2*		
Sequence ID/ Work Center II)	Operation Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
Draw Nbr	R	evision Nbr									<i>33</i>			
D3836	C													
*100		Large Fab			0.00				(20)	CC	/3-5	9		
Large Fab			Memo	004.0 1.0004.0 "	0.00									
Large Fab			2- remove 3- deburr 4- weld E to finish		gs d drill hole (3/16") using DT94	47 jig and open	١							
			6- weld D		and bushings as per dwg D383	6								

7- grind weld flush where indicated on dwg

NCR:	Yes	1	No
NCK:	yes	/	NO

DQA: _____ Date: __

NCR:	es/	/ No				WOR	CORDER NON-C	MANCE / UF	PDATE	QA Closed	l: Dat	te:			
							DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		7
Work Orde Part I	1						Rework Scrap			Skid-tube Aachining	Crosstube Small Fab Finishing	_	Water Jet od. Eng. Coor. ore/Packaging	Engineering Quality Other	
NCR I	10.					Wo	Use-as-is ork Order Update			oforming Large Fab	Composite		Supplier		
Root					Desci	iption of v	ork order update	l	nitial			Sign &		·	7
Cause		Date	Step	Qty		or Non-co	nformance	Ch	ief Eng	Des	cription	Date	Verification	n QC Inspector	╛
oc/Data															
quip/Tooling													ŀ		
perator									ŀ					ļ	
Material									l		•				-
etup				:											
ther														,,,,	
rocess													· ·		١
upplier raining															
Inapproved															
парріотеа							F.	AUL	T CATE	GORY				•	
Landi	ng (Gear					General								٦
	_	Bending				Bend			Grain			Ovalized		Pressure/Forced	
		Centre No	t Concer	ntric to (o/s	BOM/Ro	ute		Hardwa	re		Over/Und	er tolerance	Temperature/Cure	
		Cracks				Broken/	Damaged		Inspecti	on Incomplete		Part Incorr	ect	Weld	
		Crushed/0	Crimped.			Burrs			Instruct	ions Incomplete	/Unclear	Part Lost/I	Missing	Wrong Stock Pulled	
		Cuffs				Contamir	nation		Mainte	nance	L	Part Move	d		
		Heat Trea	t			Counter	sink		Mislabe	led	,	Positioned	· ·		Ì
		Inspection	n Strip in	Tube		Cut Too S			Misread	l	L	Power Los	s/Surge	Other	_
		Ripples in			L	Drill Hol			Offset						_
		Torque W	aves in E	xtrusio	n [Drawing		Out of Calibration							_
		Turning Se			L	Finish		Out of Sequence					\dashv		
		Wave/Twi	ist in Tub	e		Folio			Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ordenserver 13-1.				*900					Page 2		
Item ID: Revision ID: Item Name:	D3836-042	ly (Basket Lid, RH)		Accept	*N900	040	100)* ፡	Setup Star	1 1	S1* S2*
Start Date: Required Date: Reference:	9/13/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	• •	Cust Item I Customer:	D:					
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:		I	Run Star Sto		R1* R2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operation Description QC9- Inspect visual per of Memo	QSI004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty B-05-0	Reject Number	Insp. Stamp OAS 09
140 *1 4\O *		QC5- Inspect part compl	eteness to step on W/O	0.00	·			٧	13-05	P.O.	OAS

150

150
Packaging

Quality Control

Memo

Identify as per dwg & Stock Location: W/H

0.00

0.00

(2) 13.5-9 CC

Packaging

NCR: Y													
											QA Closed:	Date	: . <u>_</u>
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part N	-					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root		Date	Step	Qty		ption of work order update or Non-conformance		Initial Action Chief Eng Description		!	Sign & Date	Verification	QC Inspector
Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	Data /Tooling ator Prial Prial Prial If the price of					of Non-comormance		incr Errig	Des		Jule		
				·	1		AUL	T CATE	GORY				
Landi	ng G	iear				General		_			_		==
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat				o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		4 `	ion Incomplete tions Incomplete enance	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
				Cut Too Short		Misread	d		Power Loss/	Surge [Other		
				Drill Holes		Offset							
Torque Waves in Extrusion					n 🗍	Drawing		Out of	Calibration				

Out of Sequence

Outside Dimensions

Date: ___

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Ordenserver 13-1							Page 3				
Item ID: Revision ID: Item Name:	D3836-042 Rib Assemb	lly (Basket Lid, RH)		Accept	*N900	040	100)* 5	Setup Sta	I VI	S1* S2*
Start Date: Required Date: Reference:	9/13/12 9/13/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:						
Approvals:	Process P	'lan:	Date:	Tooling: SPC (Y/N):		ate:		I	Run Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

								DQA:	Date:	
NCR: Yes	s / No		_	WORK ORDER NO	N-CONFO	RMANCE / U	JPDATE	QA Closed:	Date:	
Nork Order:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
				Rewor	 	Skid-tube	Crosstube	_	Water Jet	Engineering
Part No.	•		· ·	Scra	` 	Machining	Small Fab	-1	d. Eng. Coor.	Quality Other
NCR No.	. <u> </u>			Use-as- Work Order Updat		ermoforming Large Fab	Finishing Composite	Rec/sto	re/Packaging Supplier	Other
Root				Description of work order upda	ate Initia	ıl	Action	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief I	ing De	escription	Date	Verification	QC Inspector
oc/Data										
quip/Tooling			}							
perator	_									
/laterial] .	.								
etup				·			·			
ther									,	
rocess				·						
upplier										

Landing Gear General Ovalized Pressure/Forced Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Cracks Broken/Damaged Inspection Incomplete Part Incorrect Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped_ Burrs Part Moved Cuffs Contamination Maintenance Mislabeled Positioned Wrong Countersink Heat Treat Misread Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio **Outside Dimensions**

FAULT CATEGORY

Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-13-12 1:04:33 PM

Work Order ID:

90080

Parent Item:

D3836-042

Parent Item Name:

Rib Assembly (Basket Lid, RH)

Start Date: 9/13/12

Required Date: 9/13/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 08-12-01 new issue DD verified by:eC

DD verified by:eC IPP REV:B 12.07.24 AS PER IPP REV:C 12.08.08 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	· Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	4.0000	1	1	PC i	2 0	~~~ ~
Spacer Bushing		•									CC 13	3-5-	7
				Location		Loc Qty	Lo	c Code		~			•
				WA005		4	B9876	1 -	> (2	? <i>x</i>)			
				755	64	1			-				
				772	29	1							
				811	44	2	2					-	
D4021-9		Manufactured	No			100	Each	83.0000	2	2	4		
Bushing									Lagran and the same of the sam		CCI	<u> کہ کے </u>	-4
•				Location		Loc Oty	Lo	c Code					
				WA		73	0000	77 -		4×)			
				664	37	0)	• •					
				724	82	C)						
				829	77	1	l						
				847	17	3	3						
				880		23	3			•			
				883		7	7						
				896	75	39)						
				WA005		10)						
				664		2	2						
				703		4	1						
				724	82	4	ļ						

								,		DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-O	CON	IFORM	MANCE / UP	DATE				
										QA Closed:	Date:		
144 - O					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	•	
Work Orde	er:				Rework	7 		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Qualit	
raiti		<u>.</u>			. Use-as-is	1		noforming	Finishing	1	re/Packaging	Othe	
NCR N	lo.		· · · · · · · · · · · · · · · · · · ·		Work Order Update	1		Large Fab	Composite	·	Supplier	1	
						_		· ·				·	
Root		·		Descri	ption of work order update	li	nitial	Act	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspe	ctor
Doc/Data												1	
Equip/Tooling												· ·	
Operator													
Material													
Setup													
Other													
Process													
Supplier				•				•	•				
Training													
Unapproved			<u> </u>									1	
						AUL	T CATE	GORY					,
Landir	ng Gear			_	General					1	٠,	٦. ،-	•
	Bending				Bend	\vdash	Grain			Ovalized		Pressure/Ford	
	Centre No	ot Conce	ntric to (^{D/S}	BOM/Route	\mathbf{H}	Hardwa		<u> </u>	Over/Under	-	Temperature,	Cure
	Cracks			<u> </u>	Broken/Damaged	\vdash		on Incomplete		Part Incorre	· —	Weld	5 II 1
	Crushed/0	Crimped.			Burrs	1 1	Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock	Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

September-13-12 1:04:34 PM

Work Order ID:

90080

Parent Item:

D3836-042

Parent Item Name:

Rib Assembly (Basket Lid, RH)

M304TS0.750W.065

304 SQ Tube .75x.75x.065W

Purchased

No

Start Date: 9/13/12

Required Date: 9/13/12

Start Qty: 1.00

1,362.9860

Required Qty: 1.00

1.7808 1.8745263

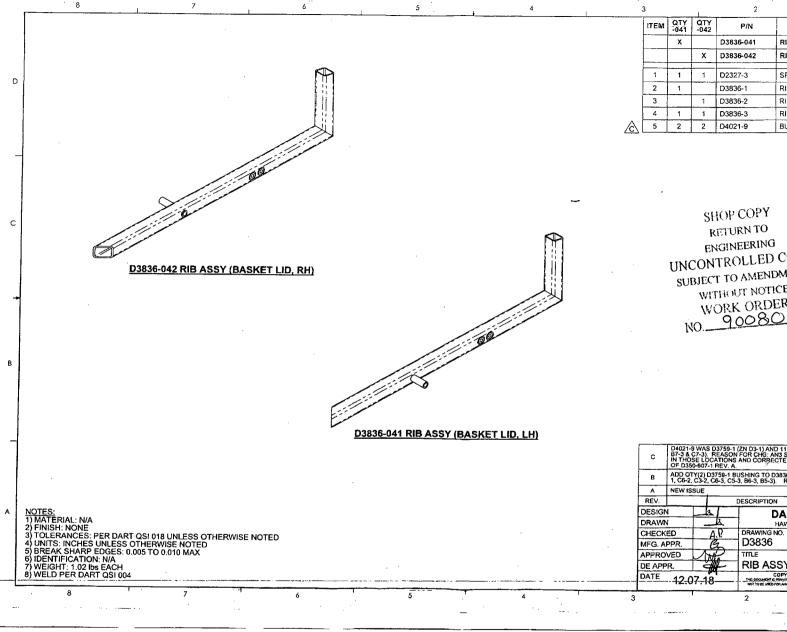
Location	Loc Qty	Loc Code
MAT	321.986	123303 -> 3,4490
112398	0	. 450 3
122051	321.986	
MAT017	1000	
122468	1000	
MAT018	41	
7636	41	

100

		DQA:	Date:	
NCR· Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	g:
Work Orde	er:		:			DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
	-					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is]	Therr	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	No.					Work Order Update]		Large Fab	Composite		Supplier	
			 	1		£:	Т.			ntion .	Cian 9		<u> </u>
Root		٠.				ption of work order update	1	initial		ction	Sign &	Verification	QC Inspector
Cause		Date	Step	Qty		or Non-conformance	Cn	ief Eng	Desc	cription	Date	vernication	QC inspector
Doc/Data	Н		1										
Equip/Tooling	Н												
Operator	Н		,										· ·
Material	Н			:]
Setup	Н												
Other													
Process													
Supplier	Н						1						
Training	Н		ŀ										
Unapproved	<u> </u>		I	<u> </u>	<u> </u>	<u> </u>	:AUI	T CATE	GORY			<u>. </u>	
Landi	ng G	ear				General		0,				···	
		Bending			Г	Bend	Г	Grain			Ovalized	Г	Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
	_	Cracks	:			Broken/Damaged		Inspect	ion Incomplete		Part Incorre	<u> </u>	Weld
	-		Crimped			Burrs		1	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	${}$	Crushed/Crimped Cuffs				Contamination		Mainte	enance		Part Moved	_	<u> </u>
	Heat Treat					Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspection Strip in Tube					Cut Too Short		Misrea	d	<u> </u>	Power Loss/	Surge	Other
	Ripples in Bend				Drill Holes		Offset		<u> </u>	_	_		
	Torque Waves in Extrusion				Drawing	Out of Calibration							
	Turning Sequence				Finish	Out of Sequence							
	Wave/Twist in Tube					Teolio	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DESCRIPTION RIB ASSY (BASKET LID, LH) RIB ASSY (BASKET LID, RH) SPACER BUSHING RIB RIB RIB BUSHING

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 90080 ML 7 12-09-13

С	B7-3 & (9 WAS D375 C7-3). REA SE LOCATIO 0-607-1 REV	69-1 (ZN D3-1) AND 11.05 WAS 11.673 (Z SON FOR CHG: AN3 SIZE BOLTS REQU DNS AND CORRECTED DIM IAW FIG 98 V. A.	MB	12.07.18	
В	ADD OTY(2) D3759-1 BUSHING TO D3836-041/-042 (ZN D3- 1, C6-2, C3-2, C6-3, C5-3, B6-3, B5-3). REASON: PAR10-50.				12.05.11	
Α	NEW ISSUE			мв	08.09.24	
REV.			DESCRIPTION	BY	DATE	
DESIGN 1		_13.	DART AEROS	DART AEROSPACE LTD		
DRAWN .				HAWKESBURY, ONTARIO, CANADA		
CHECKED		A.P.	DRAWING NO.		REV. C	
MFG. APPR.		Can	D3836		SHEET 1 OF 3	
APPROVED A			TITLE		SCALE	
DE APPR.		4	RIB ASSY (BASKET	RIB ASSY (BASKET LID) NTS		
DATE	- 12-0	7.18—	THE DOCUMENT OF PRIVATE AND CONFEDERAL AND IS SUP	COPYRIGHT © 2008 BY DART AEROSPACE LTD THE DOCUMENT IN THE WAS THE PROPERTY OF THE PROPERTY O		

